

Thursday, December 10, 2015 10:53:29 AM

139857

~~PRELIMINARY ISSUE~~

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/11/2015 **Start Qty:** 14.00 ***14***

Cust Item ID:

Required Date: 12/14/2015 **Req'd On:** 14.00 ***11***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5374	PA2 <i>Rev A</i>

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo	0.01
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Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB445 & DWG D5374

FOLIO REV: AIA

DWG REV: AZ

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB	0.00
---	------

110

QC

Memo	0.00
-------------	------

Quality Control

**DAS
45
9-89**

2015-12-10

**DAS
45
9-89**

2015-12-10

Work Order ID 139857

139857

Page 2

Thursday, December 10, 2015 10:53:29 AM

Item ID: D5374-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Bushing
 Start Date: 12/11/2015 Start Qty: 14.00 *14* Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 14.00 *14* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							38 9-89
120						(14)			DEC 11 2015
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: PRELIM	0.00							DAS 38 9-89
130						(14)			DEC 11 2015
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									JAN 2 6 2016
QC	Memo	0.02							
Quality Control									

15-12-11

POSITIVE RECALL

EFFECTIVE 15-12-10 AUTH DAS

RELEASED 9 DATE 16-01-22

Row A ECU 16-SW

Picklist Print

Thursday, December 10, 2015 10:53:28 AM

Page 1

Work Order ID: 139857

139857

Parent Item: D5374-3

D5374-3

Parent Item Name: Bushing

Start Date: 12/11/2015

Required Date: 12/14/2015

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No				f	28.8600		2.696842			

M303R0 500

303 Round Bar 0.500"

**

Location

Loc Qty

Loc Code

MAT

28.86

m133038

24.78

m133265

4.08

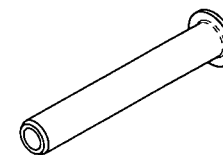
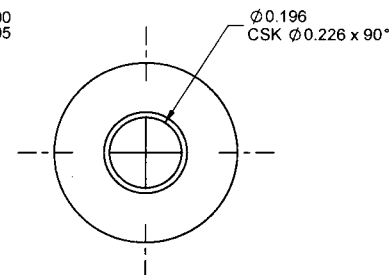
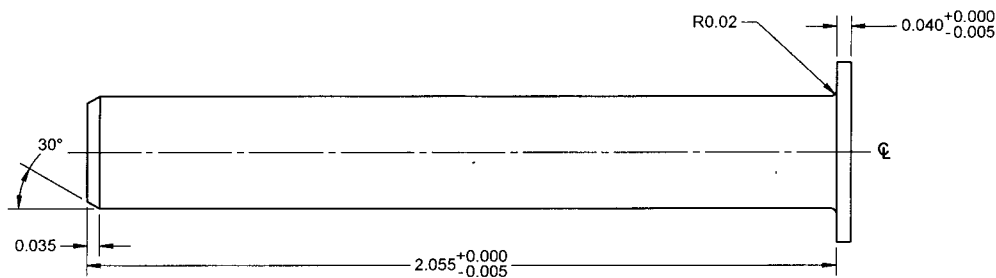
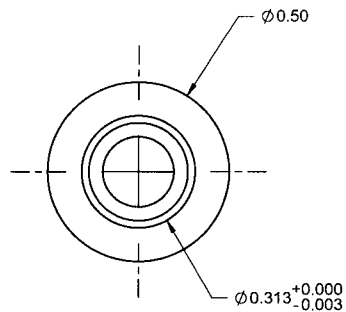
2.75 ft

DAS

45

9-89

2015-12-10



D5374-3 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
ASTM A582
OR AISI 304/316 SS ROUND BAR
PER ASTM A276
REF DART SPEC M303R OR M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. A2
MFG. APPR.	JFS	D5374	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	15.12.03	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Purchase Order Receipt Listing

Monday, September 28, 2015 9:28:07 AM

Page 1 of 2

All amounts are calculated in domestic currency.

All Vendors PO ID PO29859 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
Vendor ID \ Vendor Name		VC-COP001	Thyssenkrupp Materials CA Ltd								
PO29859	1		M6061T6B1.000X12. f		9/28/2015	9/28/2015	24.0000	\$29.63	0.0000	0	\$711.18
CAD	No		000								
			6061-T6 Bar 1.00 x f		24.0000	DCUSER		\$711.18	0.0000	0	
			12.00								
			m133265								
	2		M174R0.750 f		9/28/2015	9/28/2015	12.9000	\$5.15	0.0000	0	\$66.48
No			17-4 round bar 750 f		12.9000	DCUSER		\$66.48	0.0000	0	
			m133265								
	3		M303R0.500 f		9/28/2015	9/28/2015	24.0000	\$1.35	0.0000	0	\$32.29
No			303 Round Bar f		24.0000	DCUSER		\$32.29	0.0000	0	
			0.500"								
			m133265								
	4		M303R1.000 f		9/28/2015	9/28/2015	12.0000	\$5.61	0.0000	0	\$67.38
No			303 Round Bar 1.00 f		12.0000	DCUSER		\$67.38	0.0000	0	
			m133265								
	5		M6061T6B0.375X01. f		9/28/2015	9/28/2015	12.0000	\$2.22	0.0000	0	\$26.60
No			000								
			6061T6 BAR .375 x f		12.0000	DCUSER		\$26.60	0.0000	0	
			1.00								
			m133265								
	6		M6061T6B1.500X02. f		9/28/2015	9/28/2015	12.0000	\$8.06	0.0000	0	\$96.68
No			500								
			6061-T6 Bar 1.50 x f		12.0000	DCUSER		\$96.68	0.0000	0	
			2.50								
			m133265								
	7		M6061T6B2.500X03. f		9/28/2015	9/28/2015	12.0000	\$18.70	0.0000	0	\$224.38
No			500								
			6061-T6 Bar 2.50 x f		12.0000	DCUSER		\$224.38	0.0000	0	
			3.50								
			m133265								

Ship From: **B I L L O F L A D I N G**
THYSSENKRUPP MATERIAUX NA
4700 BOIS FRANC
ST. LAURENT, QC H4S 1A7
Tel: 514-337-0161 Fax: 514-745-2968

No: VIM 462345
Ship Date 28Sep15 at 10:33 From VFW
Probill
Via VIM DELIVERY
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-850102- 1 Your PO # 29859					
ALUMINUM FLT BAR ECONOPLT 6061-T6511					
1.00" X 12.00" X 144.0000"					
BDLE#1 R354	Heat Number Z00014085	Tag No 183588	Quantity 24 FT	PCS 2	Wt LBS 336
2) Our Order PEC-850102- 2 Your PO # 29859					
STAINLESS STEEL ROUND BAR 17-4 STAINLESS					
.750" DIA X 153.0000"					
BDLE#1	Heat Number S-11229	Tag No 176009	Quantity 12	PCS 1	Wt LBS 18
3) Our Order PEC-850102- 3 Your PO # 29859					
STAINLESS STEEL ROUND BAR 303 STAINLESS					
.50" DIA X 144.0000"					
BDLE#1	Heat Number V9V9	Tag No 184340	Quantity 24 FT	PCS 2	Wt LBS 16
4) Our Order PEC-850102- 4 Your PO # 29859					
STAINLESS STEEL ROUND BAR 303 STAINLESS					
1.00" DIA X 144.0000"					
BDLE#1	Heat Number V4J7	Tag No 184336	Quantity 12 FT	PCS 1	Wt LBS 33
5) Our Order PEC-850102- 5 Your PO # 29859					
ALUMINUM FLAT BAR 6061-T6511					
.375" x 1.00" X 144.0000"					
BDLE#1	Heat Number Z00243059	Tag No 182544	Quantity 12 FT	PCS 1	Wt LBS 5

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ETRE
RAPPORTEES IMMEDIATEMENT
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

RECU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION
TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

DATE

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

STAINLESS STEEL ROUND BAR 303 STAINLESS

.50" DIA X 144.0000"

PART NO.

PQ/R61 29859

Nous certifions que le document reproduit ici est
une copie conforme du rapport fourni par le
fournisseur du matériel ou les données résultent

Certificate of Mill Test Results

BL VIM-462345-003

28Sep15

Pg 1/1

de l'analyse faite par un laboratoire qualifié.
SIGNÉ PAR: LUCY TRUCHO



METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

740 Imperial Road North

Certificate: 92061 8

Mail To:

THYSSENKRUPP MATERIALS

A DIVISION OF THYSSENKRUPP MATERIALS NA

4700 CHEMIN DU BOIS FRANC

SAINT LAURENT, QC H4S1A7

Ship To:

THYSSENKRUPP MATERIALS

A DIVISION OF THYSSENKRUPP MATERIALS NA

4700 CHEMIN DU BOIS FRANC

SAINT LAURENT, QC H4S1A7

Date: 9/03/2015 Page: 1

Customer: 007205 001

Steel: 303

Finish: CD

Corrosion:

Your Order: VIM632041

NAS Order: PN 0055224 07

PRODUCT DESCRIPTION:

Round Bar, Annealed, Cold Draw

ASTM A582/12 EN 10204 3.1, ASTM A484/11

AMS 56400 TYPE 1, QQS-764B CONDITION A

SOLUTION ANNEAL TEMP 1900F MIN

REMARKS:

COMPLIES W/REQUIREMENTS OF DFAR 252.225-7009 EU DIRECTIVE

2011/65/EU RoHS. EAP+AOD+CC. NO WELD REPAIR. MELTED AND MFG

IN USA FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

Product Id	Skid #	Diameter	Size	Weight	Length	Mark	Pieces	Commodity Code
BH3621 5		.5000		1.063	144.00	18	1	

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Lab Accreditation Bureau, ISO/IEC 17025, Certificate# L2323

Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CO %	CR %	CU %	MN %	MO %	N %	NI %	P %
7999	US	.0432	.1455	17.0530	.3950	1.8200	.3065	.0440	8.2265	.0300
		S %	SI %							
		.3465	.5060							

MECHANICAL PROPERTIES

Product Id	1 a o i c r	HB No.	.2YS KSI	UTS KSI	RA %	Elng % 2"
BH3621 5	R L	204.0	78.65	101.59	31.11	32.25

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

AS Brown



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29859**

Purchase Order Date 9/22/2015

PO Print Date 9/22/2015

Page Number 2 of 5

Order From :

VC-COP001

Ship To : DART AEROSPACE LTD

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905 669 9444

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Ship To Phone

Terms

Net 30

Ship Via:

VENDOR'S TRUCK

Currency

CAD

Ship Acct:

FOB

FCA - (Free Carrier)

3	M303R0.500	303 Round Bar 0.500"	9/28/2015	24.00	OK	\$1.77	\$42.48
			Yes	f			
			9/28/2015				

PURCHASE MATERIAL: AISI 303 SS ROUND BAR SPECIFICATION: ASTM A582
(NOTE: AISI 304/316 NOT ACCEPTABLE)

Line Total: \$42.48

4	M303R1.000	303 Round Bar 1.00	9/28/2015	12.00	OK	\$7.39	\$88.64
			Yes	f			
			9/28/2015				

PURCHASE MATERIAL: AISI 303 SS ROUND BAR SPECIFICATION: ASTM A582
(NOTE: AISI 304/316 NOT ACCEPTABLE)

Line Total: \$88.64

5	M6061T6B0.375X01.000	6061T6 BAR .375 x 1.00	9/28/2015	12.00	OK	\$2.92	\$35.00
			Yes	f			
			9/28/2015				

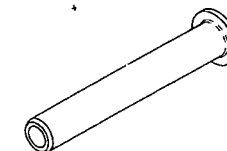
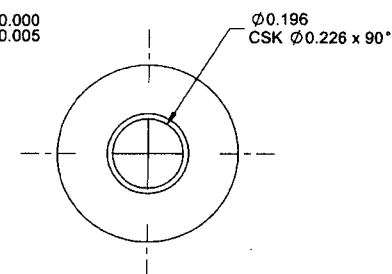
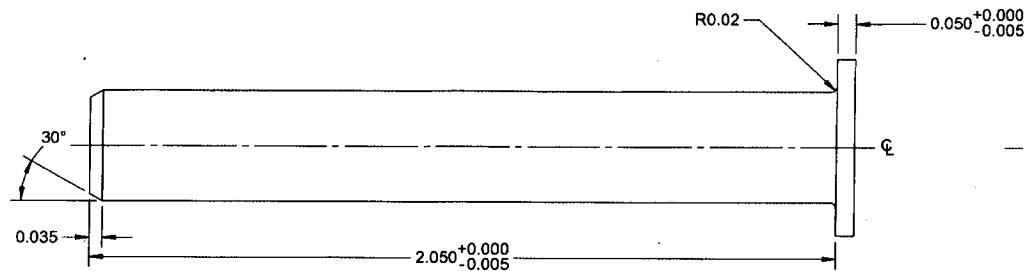
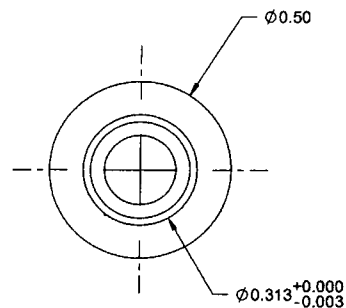
MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR
ASTM B221

Line Total: \$35.00

PO Instructions: QUOTE NO:
PEC ST-848130,ST-848130,ST-849201

Note:

9/22/2015



D5374-3 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
ASTM A582
OR AISI 304/316 SS ROUND BAR
PER ASTM A276
REF DART SPEC M303R OR M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.03 lbs

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5374	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BUSHING	NTS
DATE	15.12.03	COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	